

Work Order ID 79524

79524

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January-26-12 4:12:59 PM

Item ID: D2804-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 26/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/27 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2804	Rev C

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	Press D2805-2 into arm as per Dwg D2804								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating									

M11A480

START TIME: 10:40 OVEN TEMPERATURE:
 FINISH TIME: 11:10
32,00F

12/02/08 (2)

(2)

2X M-L 12/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Press Fit D2809 as per Dwg D2804								
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.								

2 d el 12/02/09

12/02/08 (2)

12/02/08 (2)

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: ST150	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

SB 12/02/28

(C)

(2X) SP 12-02-29

MCJ 12/02/29

ME 12-02-29

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 79524

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Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2		Manufactured	No			100	Each	0.0000	1	2			
D2804-2						B 77602			**			Ep 12/02/08	
Bracket													
D2805-2		Manufactured	No			100	Each	6.0000	1	2			
D2805-2									**			Ep 12/02/08	
Stop													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		6							
				76186		6						B 79526	
NAS1515H3		Purchased	No			100	Each	147.0000	4	8			
NAS1515H3									**			Ep 12/02/08	
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST277		147							
				116373		2							
				118078		6							
				118384		11							
				119438		28							
				120142		100							
AN3C16A		Purchased	No			150	Each	60.0000	2	4			
AN3C16A									**			Ep 12/02/08	
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		60							
				115835		1							
				118422		4							
				118628		13							
				119641		42							

M120518

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D2804-042

D2804-042


Parent Item Name: Bracket Assembly

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 2.00

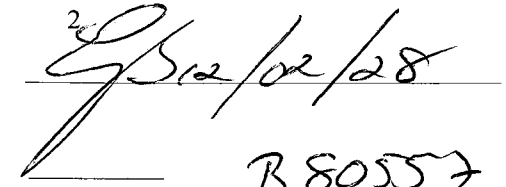
Required Qty: 2.00

 D2809
D2809
Bushing

Manufactured No

150 Each 29.0000 1

**


B80557
(20)

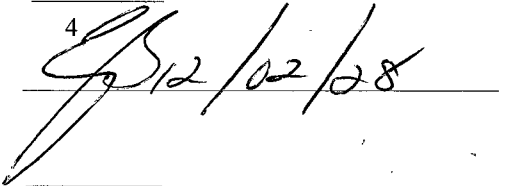
Location	Loc Qty	Loc Code
GA	7	
72735	7	
ST018	22	
34035	12	
77292	10	

MS21043-3

Purchased No

150 Each 1,170.000 2

**


M120693
(4)

MS21043-3
Nut

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST300	565	
119901	565	
ST301	533	
118077	2	
118614	441	
118686	30	
119758	60	

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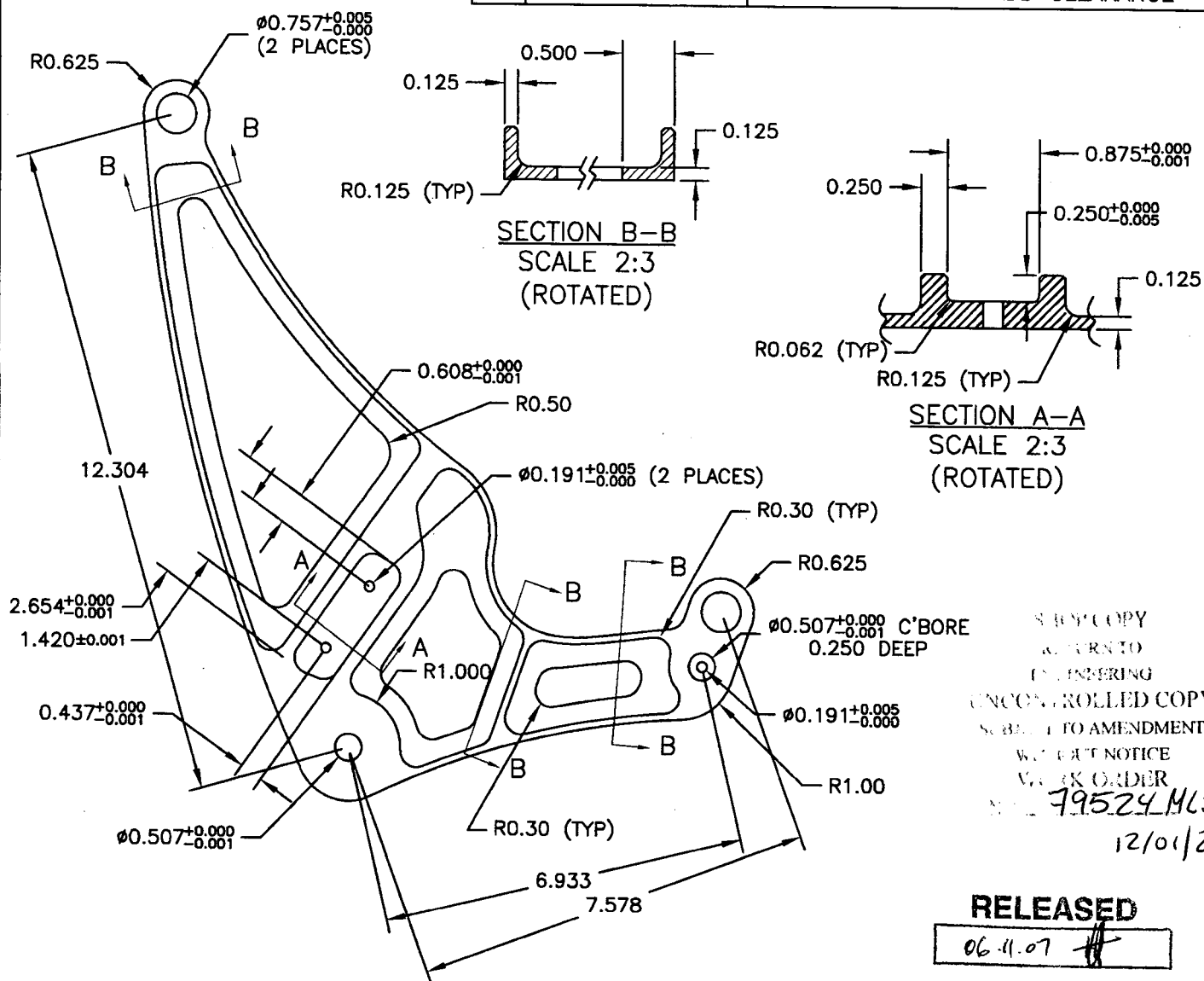
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

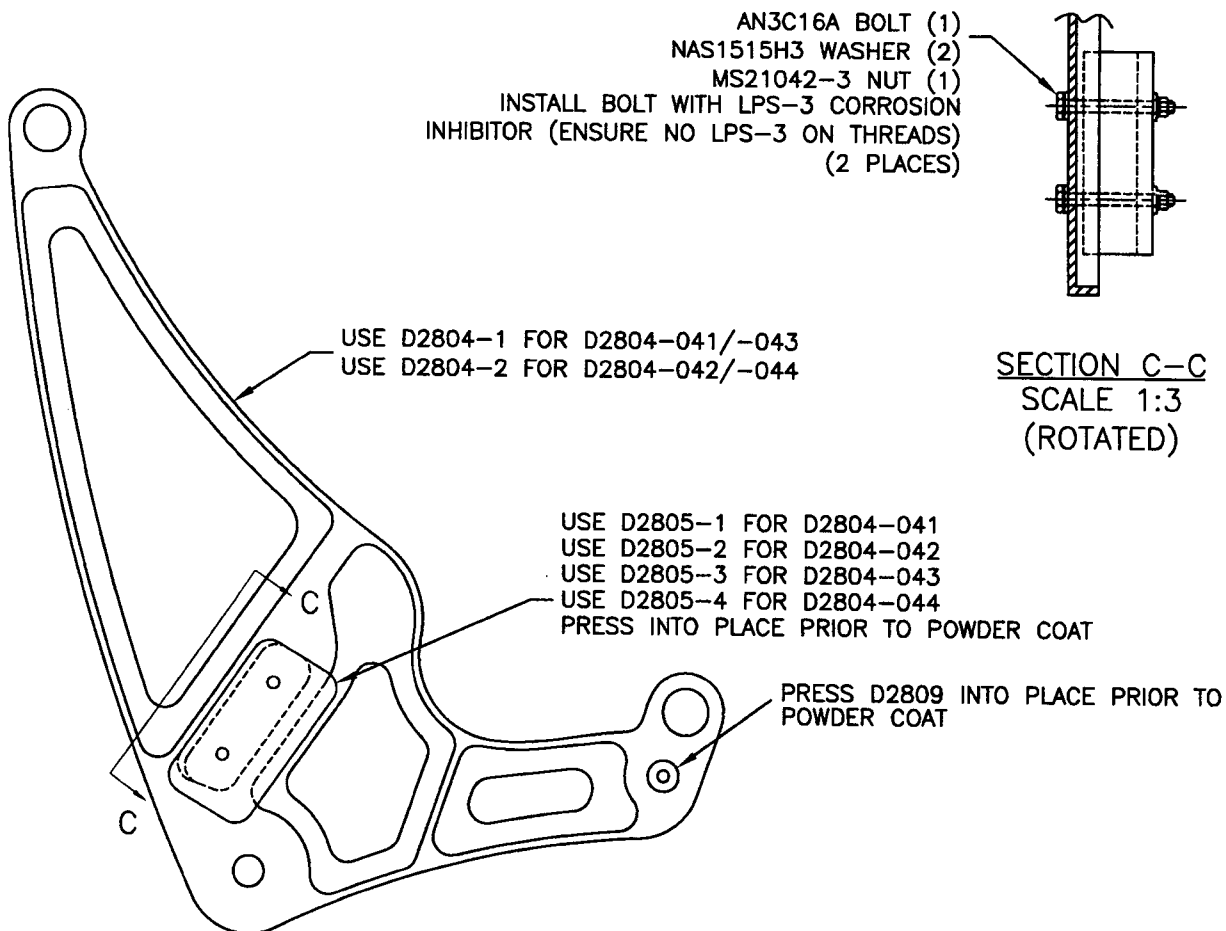
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29524

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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